

Work Order ID 63298

Wednesday, October 27, 2010 10:50:23 AM

Page 1

Item ID: D212-725-1-061F

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 10/27/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D212-725-1

E

100

0.00

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: E

Prog Rev: E

☐ 2- Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

See Attached Email about extra hubs

Siolubg

121

Hand Finish

Acid & Alodine

122 Qc 3

Al

10/10/28

2 BF 10-10-28

2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Page 2

Item ID: D212-725-1-061F

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Stop

Item Name: Bracket

Start Date: 10/27/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130  | Identify as per dwg & Stock Location: <u>384</u> | 0.00 | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | ***FLAT PATTERN ONLY*** | | | | | | | | |
| 140  | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

10/10/29
MF
10-10-29

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 27, 2010 10:50:28 AM

Page 1

Work Order ID: 63298



Parent Item: D212-725-1-061F



Parent Item Name: Bracket

Start Date: 10/27/2010

Required Date: 11/30/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-05-01 new issue DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M2024T3S.040

Purchased

No

100

sf

312.8400

0.26

0.547368



HB10-10-28

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT

75.3

114415

75.3

MAT22

237.54

110305

21.93

111786

13.76

112291

28.25

112331

52

113162

121.6

111786

2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

| | | |
|-----------------------------|---------------|-------------------------------------|
| DART AEROSPACE LTD | | Work Order: 63798 |
| Description: BRACKET | | Part Number: D212-725-1-061F |
| Inspection Dwg: | Rev: E | Page 1 of 1 |

D212-725-1-061F

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø .080 | + .004 - .001 | .083 | X | | V HB 02 | |
| Ø .098 | + .004 - .001 | .100 | ✓ | | V | |
| Ø .129 | + .005 - .001 | .132 | X | | V | |
| 10.727 | ± .010 | 10.731 | ✓ | | V PRO HB 02 | |
| .550 | ± .010 | .552 | ✓ | | V | |
| 1.100 | ± .010 | 1.100 | X | | V | |
| .600 | ± .010 | .604 | ✓ | | V | |
| .250 | ± .010 | .249 | ✓ | | V | |
| .162 | ± .010 | .165 | X | | V | |
| 1.250 | ± .010 | 1.249 | X | | V | |
| 2.394 | ± .010 | 2.398 | ✓ | | V | |
| 2.724 | ± .010 | 2.726 | ✓ | | V | |
| .903 | ± .010 | .904 | X | | V | |
| 1.183 | ± .010 | 1.182 | X | | V | |
| 1.978 | ± .010 | 1.979 | ✓ | | V | |
| 4.376 | ± .010 | 4.374 | ✓ | | V | |
| 3.157 | ± .010 | 3.160 | ✓ | | V | |
| 3.348 | ± .010 | 3.349 | ✓ | | V | |
| .040 | ± .010 | .039 | ✓ | | V | |
| | | | | | | |
| | | | | | | |
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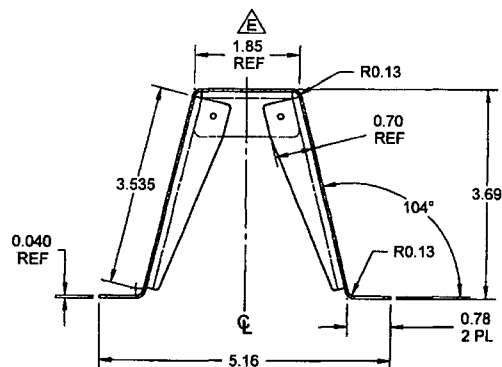
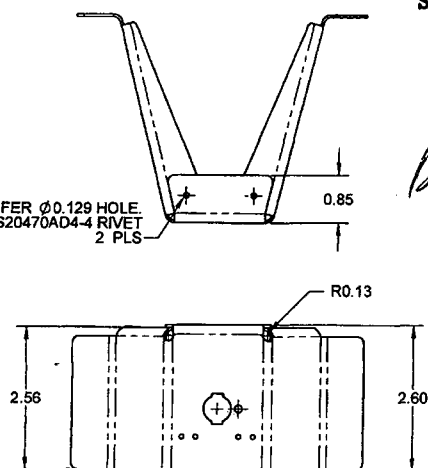
| | | |
|------------------------|-----------------------|----------------------------|
| Measured by: IB | Audited by: S | Prototype Approval: |
| Date: 10-10-28 | Date: 10/10/28 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |

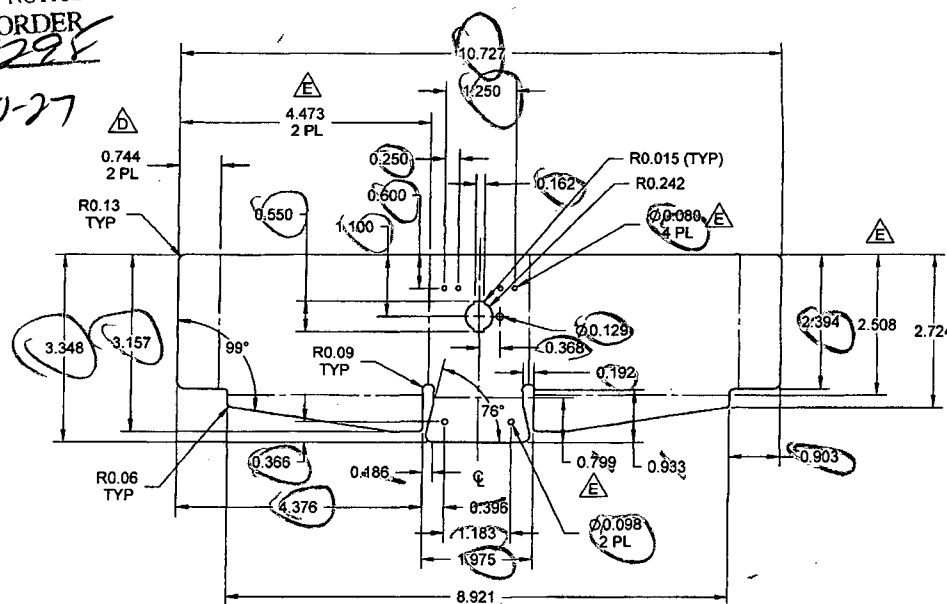
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63298

BR 10-27

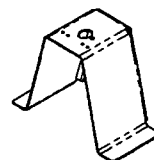
TRANSFER Ø0.129 HOLE
INSTALL MS20470AD-4 RIVET
2 PLS



D212-725-1-061 BRACKET
(MAKE FROM D212-725-1-061F FLAT PATTERN)



D212-725-1-061F FLAT PATTERN



RELEASED
2009-10-28

NOTES:

- 1) MATERIAL: 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S 040)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

| | | | |
|------------|--------------------|--|----------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RF | DRAWING NO. | REV. E |
| MFG. APPR. | N/A | D212-725-1 | SHEET 25 OF 82 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | 212S DETAIL PARTS | NTS |
| DATE | 08.09.17 | COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

L Lacelle

From: Robert Fuentes [rfuentes@dartaero.com]

Sent: October 27, 2010 1:03 PM

To: 'L Lacelle'

Cc: 'H. Siemeris'; 'David Shepherd'

Subject: RE:

That be ok Linda, send that part as is, If they have problem I correct that when we release D-4 digits number.

Roberto

From: L Lacelle [mailto:llacelle@dartaero.com]

Sent: Wednesday, October 27, 2010 9:47 AM

To: 'Robert Fuentes'

Cc: 'H. Siemens'; 'David Shepherd'

Subject: FW:

Roberto,

I have had these cut already to the dxf's you supplied, I can charge Eagle for the scrap parts, or you take them as is...what is your preference?

Please next time let someone know that the drwg or dxf is changed, we NEVER receive an ECN for the change in these parts, so no one knows about it!

LL

From: David Duval [mailto:dduval@dartaero.com]

Sent: October 27, 2010 11:43 AM

To: Linda Lacelle

Subject:

d212-725-1-123 do we cut it or what

[11:31:31 AM] David Duval: the rad is at 4.00"

[11:34:53 AM] Roberto Fuentes: the new radius is 3.75" from same center as old

[11:36:13 AM] David Duval: send me the new dxf with the new dwg

[11:41:32 AM] Roberto Fuentes: ok, I will send to replace old file that you have.

[11:42:22 AM] David Duval: plus the dxf you sent me is missing the 2 bottom hole .25"

David Duval

Production Engineering Coordinator



1270 Aberdeen Street

Hawkesbury Ontario

Canada K6A 1K7

Tel:(613)632-6200

dduval@dartaero.com



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10/27/10